

Date: Monday, 2/6/2006 11:28:18 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACK
Job Number	: 25724		
Estimate Number	: 10879		
P.O. Number	: N/A	Part Number	: D32501
This Issue	: 2/6/2006 S.O. No. : N/A	Drawing Number	: D3250 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 2/13/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est. B 04.10.26 D3250-1 no longer made in-house		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

MAKE BY HAND

RECORD MATERIAL, QTY AND BATCH NUMBER

DEBURR AND BEND PER DRWG

2024T3.063 22" x 21" X2
M 19089

SB 06/02/06

PTD

2.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

[Signature]

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SB 06/02/07

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

[Signature]

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 06 02 07

6.0 POWDER COATING POWDER COATING



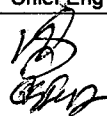
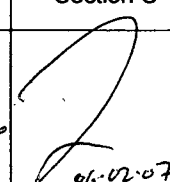
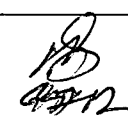
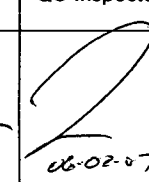
Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 02 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/06	1	1 piece was scrap missing radius on the drawing.		Scrap - destroy replace	SB 06/02/06	 06-02-07		 06-02-07

NOTE: Date & initial all entries

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Drawing Name: BACK

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Part Number: D32501

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C206/02/07

①

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ✓

C206/02/07 ①

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/07

Job Completion



06-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

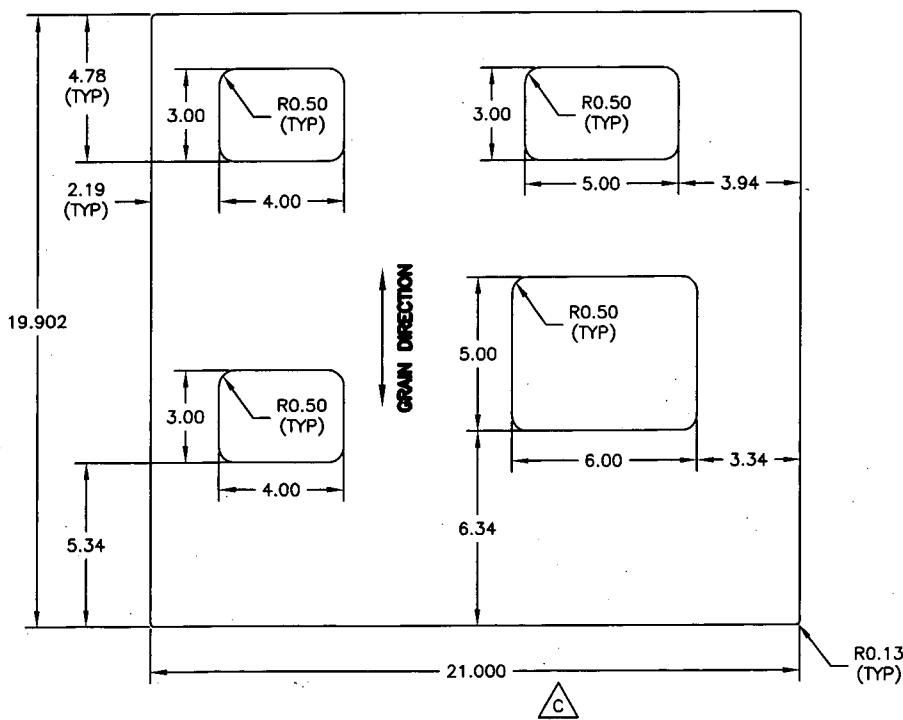
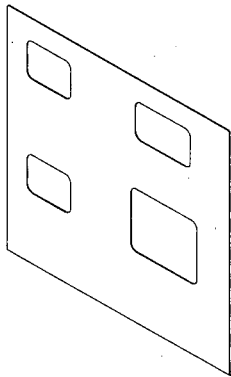
QA: N/C Closed: _____ Date: _____

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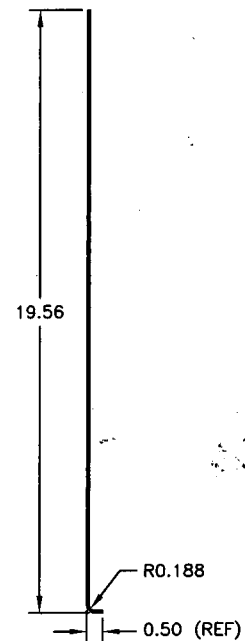
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3250	REV. C SHEET 1 OF 1
DATE 06.02.01	TITLE BACK (DUAL BATTERY RACK)		SCALE 1:6
A	04.04.06	NEW ISSUE	
B	04.11.04	20.625 WAS 20.243	
C	06.02.01	20.875 WAS 20.625, REMOVE $\phi 0.501$ TOOLING HOLES	



D3250-1F FLAT PATTERN



D3250-1 BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Linda Lacelle

From: Jason Loader [jloader@eaglecopters.com]
Sent: Monday, February 06, 2006 4:21 PM
To: 'Linda Lacelle'
Subject: RE: D205-579-015 Dual Battery Rack

Yes, this one will finish their current completion. The production run in 4-6wks will give lots of time for their next completions.

Jason

-----Original Message-----

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: Monday, February 06, 2006 9:20 AM
To: 'Jason Loader'; 'Marc Bellavance'; 'Peggy McDonald'
Cc: 'Bill Beckett'
Subject: RE: D205-579-015 Dual Battery Rack

We will make one by hand, do you only need the one of each?

-----Original Message-----

From: Jason Loader [mailto:jloader@eaglecopters.com]
Sent: Friday, February 03, 2006 1:46 PM
To: 'Marc Bellavance'; 'Peggy McDonald'
Cc: 'Bill Beckett'; 'Linda Lacelle'
Subject: RE: D205-579-015 Dual Battery Rack

Ron at Heli-Trade is working on a completion of a 205 right now and requires the wider panels. He is hoping it might be possible to get the revised panels in about four weeks, 6 weeks will push it near the due date of the completion. He would much rather wait for the wider panels than install the kit with shims. Is there any chance of meeting this time frame?

Jason

-----Original Message-----

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Friday, February 03, 2006 11:35 AM
To: Peggy McDonald
Cc: Bill Beckett; Linda Lacelle; 'Jason Loader'
Subject: D205-579-015 Dual Battery Rack

Hi Peggy,

As per our last conversation, here are the part numbers:

- 1) D3249-1 Top Panel
- 2) D3250-1 Back Panel

We revised above flat patterns to extend the width of our Dual Battery Racks from 20.75" to 21.25".

According to Jason Loader, this should fix the problem of Heli-Trade.